

Work Order ID 48514

Page 1

June 26, 2009 12:45:40 PM

Item ID: D2662-2**Accept****Setup****Start****Revision ID:** D**Stop****Item Name:** Saddle, RH In 206**Start Date:** 15/07/2009 **Start Qty:** 6.00**Cust Item ID:****Required Date:** 03/08/2009 **Req'd Qty:** 6.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run****Start****QC:****Date:****SPC (Y/N):****Date:****Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2662	Rev D

100



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. Inspect part number and batch number are programmed correctly. Fixturing Inspection last completed _____ by _____ Machine Step No 1 of Folio and inspect per attached Dimension Sheet Machine Step No 2 of Folio



110



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet



120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control



finishing
old workshop

Date: Thursday, 11/06/2009 1:55:00 PM
 User: Jean-Luc Menard

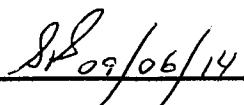
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 SADDLE, INBOARD, RIGHT SIDE	
Job Number	: 48514		Part Number	: D26622	
Estimate Number	: 12130		Drawing Number	: D2662 REV D	
P.O. Number	:		Project Number	: N/A	
This Issue	: 11/06/2009		Drawing Revision	: D	
Prsht Rev.	: NC		Material	:	
First Issue	: / /		Due Date	: 18/06/2009	
Previous Run	:		Qty:	6 Um: Each	
Written By	: <i>JLM 09/06/11</i>				
Checked & Approved By	:				
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC Est Rev:D As per Rev D 07-03-19 JLM				

PENDING
RECALL

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description:
1.0	D6101001 	Saddle Billet 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6X6.25 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length Batch No: <u>16409</u>		
2.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1 

Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. Inspect part number and batch number are programmed correctly. Fixturing Inspection last completed <u>09/06/11</u> by <u>MAT</u> Machine Step No 1 of Folio and inspect per attached Dimension Sheet Machine Step No 2 of Folio and inspect per attached Dimension Sheet Machine Step No 3 of Folio and inspect per attached Dimension Sheet Machine Step No 4 of Folio and inspect per attached Dimension Sheet Deburr		
 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2662-2 PAR #: Fault Category: bad machined parts NCR: Yes No DQA: / Date: 05/05/15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 05/11/25

NCR: 48514		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/05/15	2	AREA ON SKID FLANGE IS 0.020" LOWER THAN REMAINING FLANGE operator error / origin 0.137" error	OP 05/05/15 P/C 05/04/15	High stress area. SCRAP PART = replace	OP 09/09/10 P/C 05/05/10	OP 05/05/10	OP 05/05/15 P/C 05/05/12	OP 05/05/10
05/05/15	2	Ridge of .250 ± 5 .005" under tolerance. operator RC, scrap error / origin.	OP 05/05/15 P/C 05/04/15	OP 05/05/15 P/C 05/04/15	OP 09/06/15 P/C 05/05/10	OP 05/05/10	OP 05/05/10	OP 05/05/10
05/06/15	2	WALL THICKNESS AT DIM "J" IS UP TO 0.137". operator error / off set	OP 05/06/16 P/C 05/04/15	WALL THICKNESS UP TO 0.140" OK AT THIS LOCATION.	mm= 09/06/16 P/C 05/05/10	OP 05/05/10	OP 05/05/15 P/C 05/05/10	OP 05/05/10

NOTE: Date & initial all entries → LCR

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206 SADDLE, INBOARD, RIGHT SIDE
Job Number: 48514		Part Number: D26622
Job Number:		
Seq. #:	Machine Or Operation:	Description :
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		09/06/22 J.A. /  89 09/06/23
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		89 09/06/23
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		SL 09/06/24
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		UMD 09/06/24
7.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		MILL 472
START TIME: 2:15pm OVEN TEMPERATURE: 370° FINISH TIME: 2:45pm		HL 89-06-24 X6
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		19/8/27 (6)
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST435		19/5/18 (6)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		09/09/08 (6)
Job Completion		 09/09/09 POSITIVE RECALL EFFECTIVE 09/06/12 AUTH 11 RELEASED 1 DATE 09/06/09

DART AEROSPACE LTD

Work Order:

48514

Description: 206 Saddle, Inboard, Right side

Part Number:

D2662-2

Inspection Dwg: D2662 Rev. D

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.110	.109	.107	.108		
B	0.100	0.140		.135	.140	.136	.137		
C	1.125	1.145		1.140	1.136	1.136	1.135		
D	0.615	0.685		.675	.672	.677	.670		
E	0.240	0.260		.253	.250	.247	.248		
F	1.313	1.343		1.340	1.318	1.319	1.318		
G	0.210	0.230		.225	.230	.225	.227		
H	0.100	0.180		.132	.125	.127	.130		
I	2.470	2.510		2.493	2.486	2.488	2.497		
J	1.565	1.585		1.575	1.573	1.574	1.574		
K	0.235	0.240		.235	.235	.235	.235		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.005	1.006	1.001	1.004		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.248	1.249	1.250	1.250		
Q	2.495	2.505		2.500	2.499	2.498	2.500		
R	0.313	0.318		.316	.316	.316	.316		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.497	2.497	2.499		
U	1.357	1.367		1.361	1.360	1.360	1.360		
V	0.787	0.807		.794	.792	.792	.793		
W	0.540	0.560		.550	.540	.545	.545		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.924	.925	.925	.925		
AA	0.490	0.510		.500	.498	.498	.501		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: MWF
Date: 09/06/16Audited by: JL
Date: 09/06/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<u>Jeff</u>

DART AEROSPACE LTD	Work Order: 48514
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance		Actual Dimension ⁴	Accept ⁵	Reject ⁶	Method of Inspection	Comments
	Min	Max					
A	.100	.140	.109	.109	.109		
B	.100	.140	.138	.138	.138		
C	1.125	1.145	1.136	1.136	1.136		
D	.615	.685	.680	.683	.680		
E	.240	.260	.249	.250	.250		
F	1.313	1.343	1.318	1.318	1.318		
G	.210	.230	.227	.227	.230		
H	.100	.180	.130	.131	.130		
I	2.470	2.510	2.485	2.490	2.488		
J	1.565	1.585	1.574	1.574	1.574		
K	.235	.240	.235	.235	.235		
L	.100	.120	.110	.110	.110		
M	.990	1.010	1.003	1.003	1.003		
N	.510	.515	.510	.510	.510		
O	5.990	6.010	6.001	6.001	6.001		
P	1.245	1.255	1.250	1.250	1.250		
Q	2.495	2.505	2.500	2.499	2.500		
R	.313	.318	.316	.316	.316		
S	.315	.322	.316	.316	.316		
T	2.495	2.505	2.497	2.498	2.497		
U	1.357	1.367	1.360	1.360	1.361		
V	.787	.807	.792	.794	.794		
W	.540	.560	.540	.542	.543		

Measured by:	MWF	Audited by:	JL	Prototype Approval:	N/A
Date:	09/06/17	Date:	09/06/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Suite →
1.2

Suite 1.2

DART AEROSPACE LTD	Work Order:	48514
Description: 206 Saddle, Inboard, Right side	Part Number:	D48514-2
Inspection Dwg: D48514	Rev:	1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>MM</u>	Audited by: <u>SL</u>	Prototype Approval: N/A
Date: <u>09/06/17</u>	Date: <u>09/06/24</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

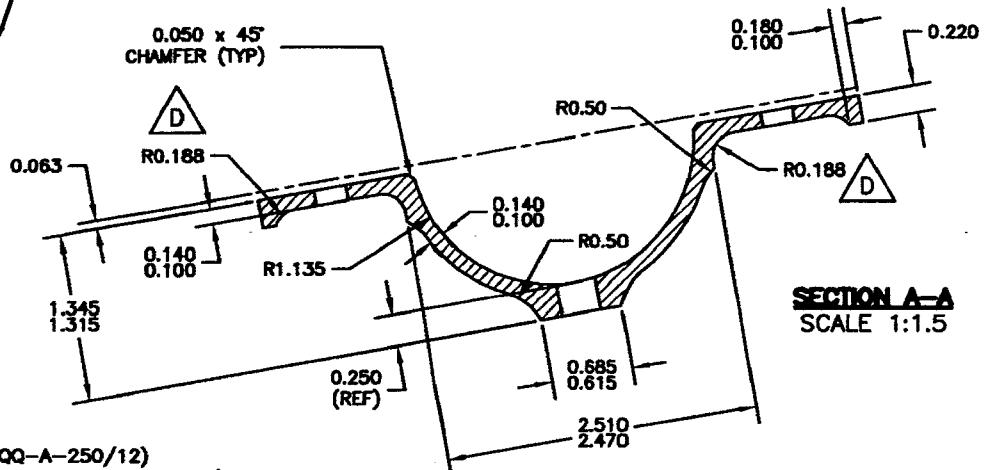
DART

DESIGN A	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED PH	APPROVED CH	DRAWING NO. D2662	REV. D	SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE INSIDE	SCALE 1:3	
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.29	INCORP' DEO 9122/9102/9095/9137		
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313		

2025 RELEASED

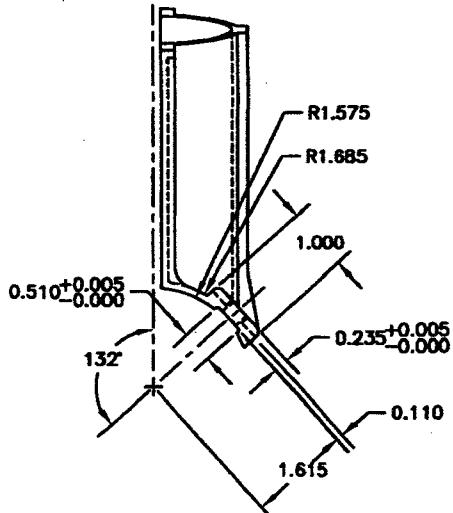
07.02.12 ~~af~~

1-2514

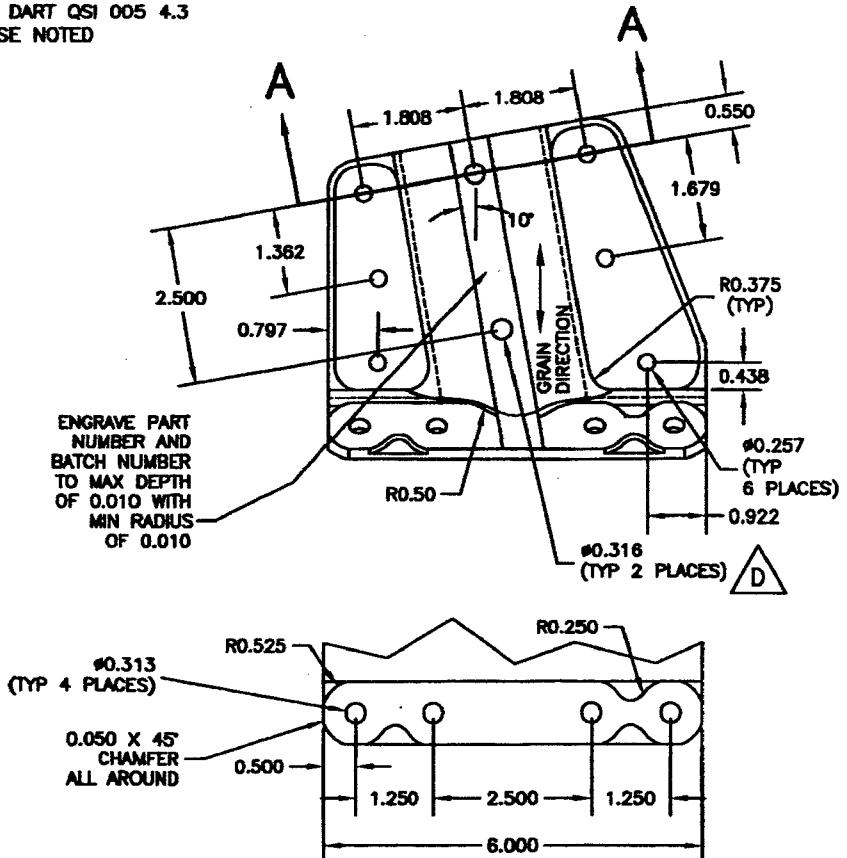


NOTES:-

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)



D2662-1 SADDLE INSIDE



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